

Work Order ID 52482

September 25, 2009 2:33:04 PM



Page 1

Item ID: PB67-43001-09 **GN**
 Revision ID: B1
 Item Name: Aft Blade Fold Assembly Weldment
 Start Date: 10/05/2009 Start Qty: 2.00
 Required Date: 10/16/2009 Req'd Qty: 2.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: mf Date: 09-09-25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	Rev B1								

100



Large Fab

Large Fab

Large Fab

Memo

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001□** ensure
 no burn thru after welding in tube -235 and -229 only where bushing -265 ***

0.00

0.00

09.10.19

2

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

PD

09.10.19 (2)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2780910119

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 52482

September 25, 2009 2:33:04 PM



Page 2

Item ID: PB67-43001-09

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/05/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/16/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____

Date: _____ Tooling: _____

Date: _____

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

M 1814 c

⇒ JH 09/10/20 22 9

Powder Coating

Memo

0.00

in detail D, mask in between -311 prior to paint□***mask 1.750" on the end of -243 prior to paint***□***mask inside of D3440-9 prior to paint***□START TIME:

8:15a □FINISH TIME:

7:45a □OVEN TEMPERATURE: 320F

140



QC

QC3- Inspect Part Finish

0.00

bk 09-10-20

2

Quality Control

Memo

0.00

150



Packaging

Identify as per dwg & Stock Location:

0.00

pl

Memo

0.00

pl 09/10/21

Packaging

W/O:		WORK ORDER CHANGES					
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September 25, 2009 2:33:04 PM

Page 3

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Revision ID: B1

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/21
mf 09-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

September 25, 2009 2:33:04 PM

Page 1

Work Order ID: 52482

Parent Item: PB67-43001-09RevB1

Parent Item Name: Aft Blade Fold Assembly Weldment


Comments:

Start Date: 10/05/2009

Required Date: 10/16/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3440-13RevA		Manufactured	No			100	Each	5.0000	2.0000			
												
Bracket (Supersedes B67-43001-273)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse


ST

41452

5

5

MF 09-10-03

D3440-9RevA		Manufactured	No			100	Each	3.0000	2.0000			
												
Tube Detent Clip Base (Supersedes B67-43001-241)												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41456

3

3

MF 09-10-03

PB67-43001-201RevB1		Manufactured	No			100	Each	7.0000	4.0000			
												
Square Tube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40592

44990

7

3

4

MF 09-10-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

September 25, 2009 2:33:04 PM

Work Order ID: 52482



Parent Item: PB67-43001-09RevB1



Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/05/2009

Required Date: 10/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-203RevB1		Manufactured	No			100	Each	5.0000	2.0000			
Square Tube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

41907

5

MF 09-10-03

PB67-43001-209RevB1		Manufactured	No			100	Each	0.0000	2.0000			
Square Tube												

652485x2 MF 09-10-03

PB67-43001-211RevB1		Manufactured	No			100	Each	23.0000	12.0000			
Square Tube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

23

44989

23

2x 52486.
x10 MF 09-10-03

PB67-43001-213RevB1		Manufactured	No			100	Each	1.0000	4.0000			
Flanged Hook												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

1

41488

1

MF 09-10-03

September 25, 2009 2:33:04 PM

Shop Packet Print

Page 2

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September 25, 2009 2:33:04 PM

Page 3

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Parent Item Name: Aft Blade Fold Assembly Weldment

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PB67-43001-229RevB1		Manufactured	No			100	Each	0.0000	2.0000			
Outer Tube												
PB67-43001-235RevB1		Manufactured	No			100	Each	2.0000	2.0000			
Outer Tube												

09.10.15 B52608

09.10.15 B41490

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST



41490

45260

2

x 2

1

MF 09-10-03

PB67-43001-239RevB1

Manufactured No



Square Tube

100

Each

6.0000

2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

44986

46633

6

5

1

MF 09-10-03

September 25, 2009 2:33:04 PM

Shop Packet Print

Page 3

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Page 4

September 25, 2009 2:33:04 PM

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Parent Item Name: Aft Blade Fold Assembly Weldment

Start Date: 10/05/2009

Required Date: 10/16/2009

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Start Qty: 2.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-243RevB1		Manufactured	No			100	Each	5.0000	2.0000			
Tube Handle Extension												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

43332

5

MF 09-10-03

PB67-43001-277RevB1 Manufactured No



Contoured Male Eye

100

Each

2.0000

2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2

40059

2

MF 09-10-03

PB67-43001-311RevB1 Manufactured No



Restraint

100

Each

4.0000

4.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4

41502

4

MF 09-10-03

September 25, 2009 2:33:04 PM

Shop Packet Print

Page 4

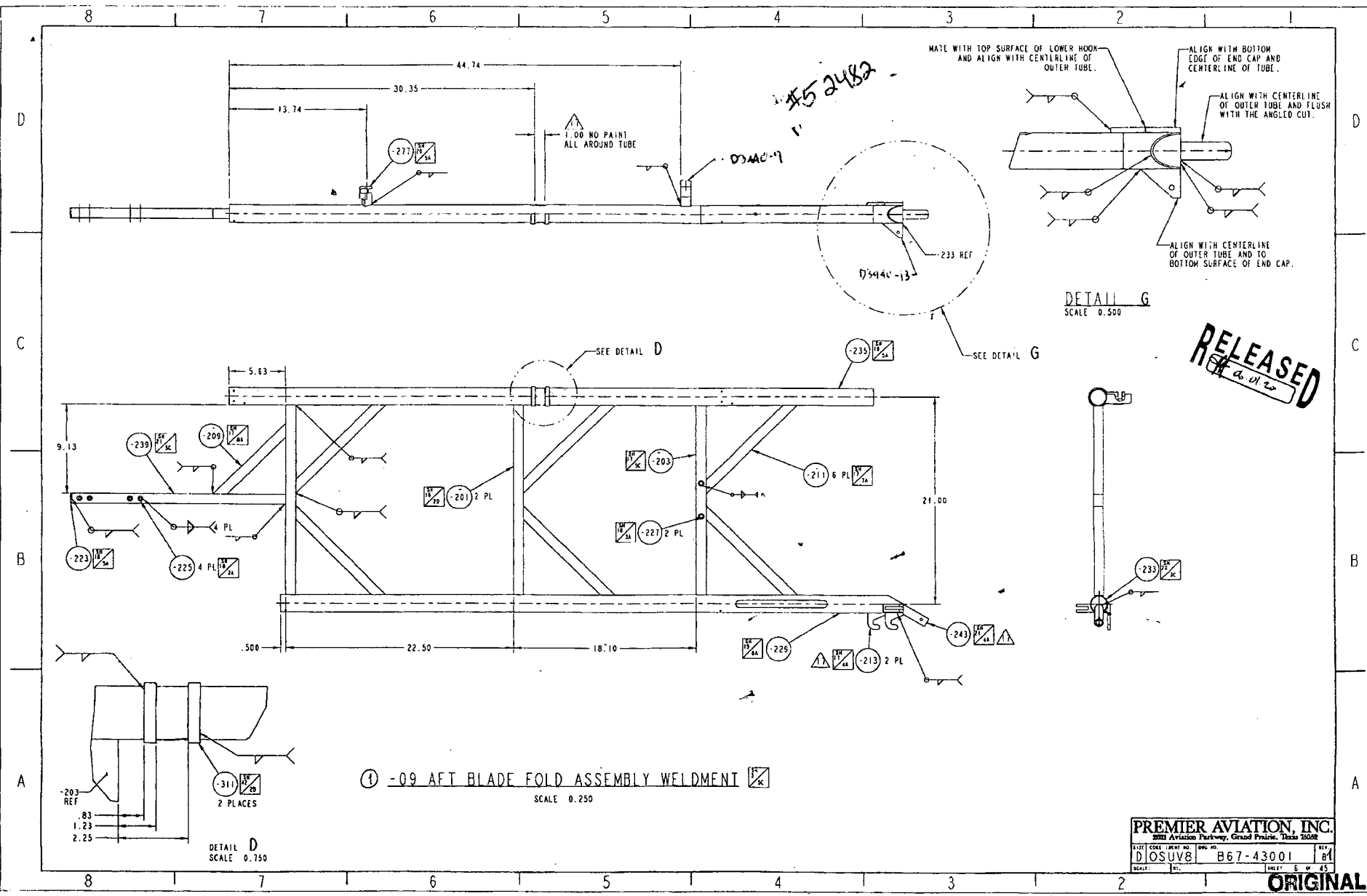
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① -09 AFT BLADE FOLD ASSEMBLY WELDMENT

SCALE 0.250

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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